

D5046-1

B417555

SPLIT-2

Work Order ID 117555-1

117555

Page 1

April-25-14 10:21:24 AM

Item ID: D5046-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Co-Pilot Collective Head

8.0

Start Date: 5/07/14

Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/07/14

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5046

A

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 5.500"

12

8

MH 14/05/02

110

0.00

110

HAAS 1

Memo

0.00

HAAS-CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB296/ D5046-1

FOLIO REV: A+DWG REV: ADAS
08
9-89

S. 14/05/08

DAS
14
9-89

14/05/07

DO NOT BUFF OR POLISH PART

DEBURR

April-25-14 10:21:24 AM

Page 2

Stop *NR2*

0.00

Quality Control

DAS
14
9-89

14/05/07

045
13
8-89

14-575

13
9-89

14-5-14

Work Order ID 117555

117555

Page 3

April 25-14 10:21:24 AM

Item ID: D5046-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Co-Pilot Collective Head
Start Date: 5/07/14 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 5/07/14 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number DAS 37 9-89	Insp. Stamp
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8	0		14-05-18
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>WA002</u> Memo	0.00 0.00				8			14-05-22 MAL
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							14/5/22 JF ME 14-5-22

Picklist Print

April-25-14 10:21:24 AM

Page 1

Work Order ID: 117555

117555

Parent Item: D5046-1

D5046-1

Parent Item Name: Co-Pilot Collective Head

Start Date: 5/07/14

Required Date: 5/07/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV. A NEW ISSUE JFS 14/04/11 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M3061T6B2.000X05.00 0		Purchased	No			100	f	2.5000	0.46	6			

M6061T6B2 000X05 000

**

6061T6 Bar 2.00 x 5.000

Location

Loc Qty

Loc Code

MAT

2.5

m128866

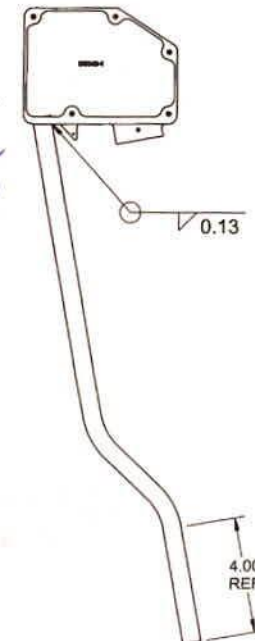
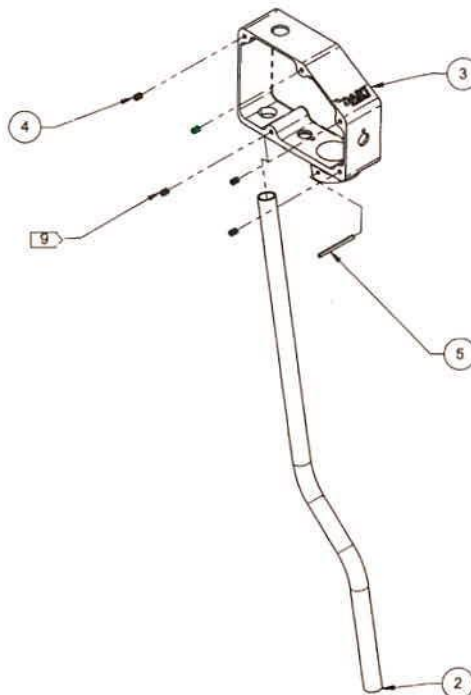
2.5

m 128980

2.5
~~2.5~~
3.275

MH
14/05/02

ITEM	QTY	P/N	DESCRIPTION
1	X	D5046-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-7	CONDUIT
3	1	D5046-1	CO-PILOT COLLECTIVE HEAD
4	5	90296A108	HELL-COIL INSERT (6-32 X 0.276)
5	1	MS171539	PIN



11755 MLT
1404-25

D5046-041 WELDING DETAIL

RELEASED
2014-04-06

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.91 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

D5046-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)

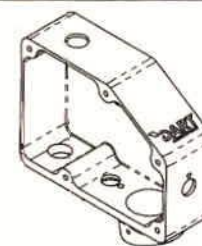
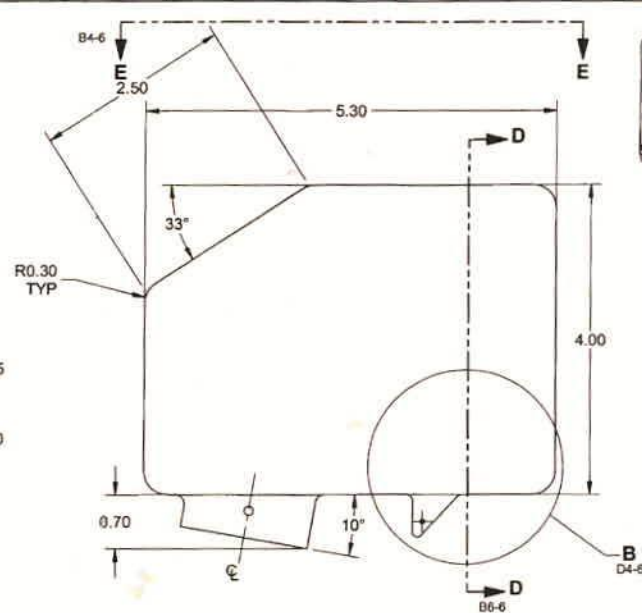
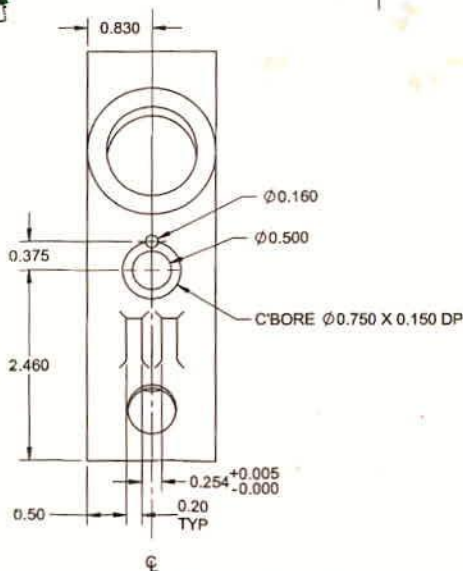
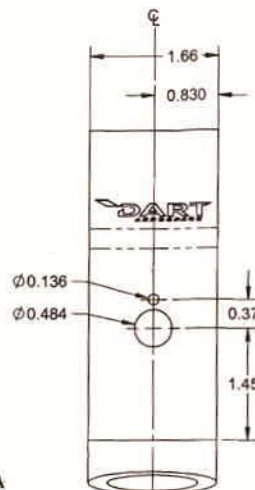
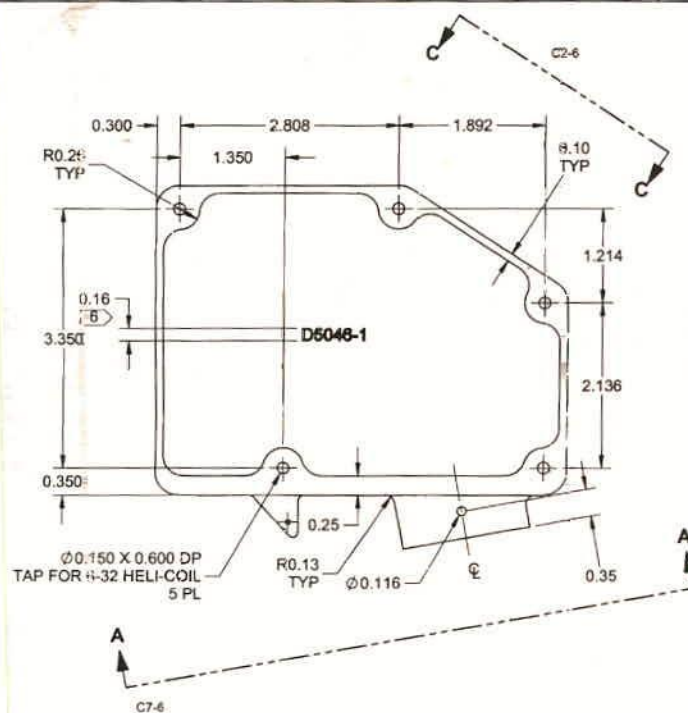
APPROVED

REV.	DESCRIPTION	VS	DATE
A	NEW ISSUE	VS	14.01.22
DESIGN	VS		
DRAWN	VS		
CHECKED	DC		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	14.01.22		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. REV. A
D5046 SHEET 1 OF 12
TITLE SCALE
CO-PILOT COLLECTIVE HEAD NTS

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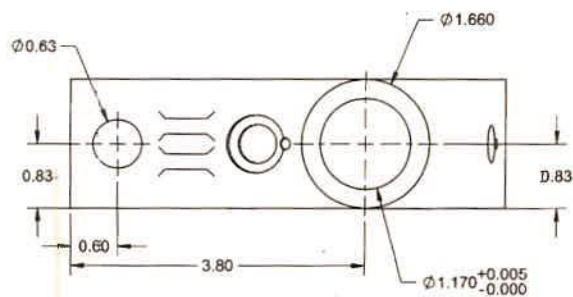
- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116;
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
 - 7) WEIGHT: 0.74 lbs

D5046-1 CO-PILOT COLLECTIVE HEAD (205)

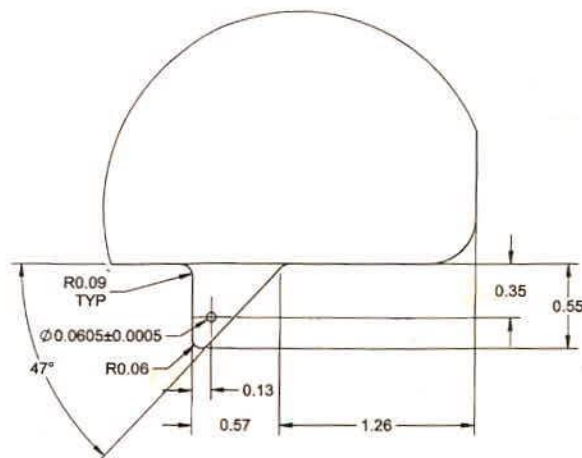
APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5046	SHEET 5 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	14.01.22	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC.	
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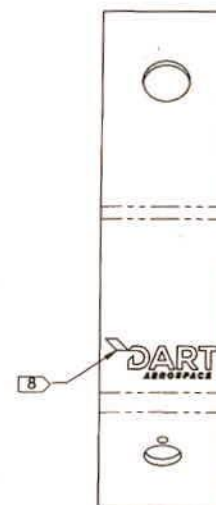
RELEASED
2014-04-04



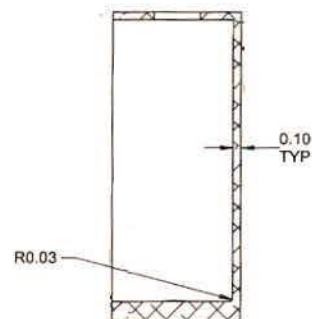
VIEW A-A
B7-5



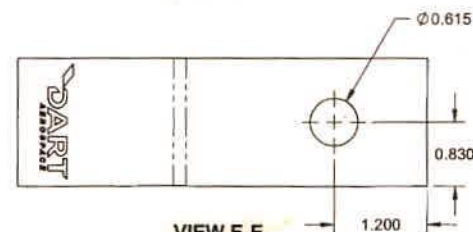
DETAIL B
C2-5



VIEW C-C
D6-5



SECTION D-D
C2-5



VIEW E-E
D3-5

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.24 lbs
 - 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP

D5046-1 CO-PILOT COLLECTIVE HEAD (205)
DETAIL VIEWS

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5046	SHEET 6 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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RELEASED
2014-04-04
WP

DART AEROSPACE LTD		Work Order: 1
Description: CD-PILOT COLLECTIVE HEAD		Part Number: D5046-1
Inspection Dwg: D5046 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.350	± 0.05	3.350	—		Vern	ML-06
R.26	± 0.30	R.260	—		R-6	
.300	± 0.05	.300	—		Vern	ML-06
1.350	± 0.05	1.350	—		"	
2.808	± 0.05	2.808	—		"	
1.892	± 0.05	1.892	—		"	
.10	± 0.30	.098	—		"	
1.214	± 0.05	1.214	—		"	
2.136	± 0.05	2.136	—		"	
.35	± 0.30	.348	—		"	
Ø.116	± 0.009 ± 0.01	Ø.116	—		"	
R.13	± 0.30	R.125	—		R-6	
.25	± 0.30	.249	—		Vern	ML-06
Ø.150	± 0.005 ± 0.01	Ø.150	—		"	
1.66	± 0.30	1.658	—		"	
.830	± 0.05	.830	—			
Ø.136	± 0.005 ± 0.01	Ø.136	—			
Ø.484	± 0.006 ± 0.01	.485	—			
.375	± 0.10	.375	—			
1.450	± 0.10	1.450	—			
5.30	± 0.30	5.300	—		Vern	ML-06
4.00	± 0.30	3.996	—		"	
.70	± 0.30	.695	—		"	

Measured by: DAS 14
Date: 14/05/18

Audited by: DAS 37
Date: 14.05.18

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD		Work Order:
Description: CO-PILOT COLLECTIVE HEAD		Part Number: D5046-1
Inspection Dwg: D5046 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10°	± 1/2°	10°	—		C-square	
33°	± 1/2°	33°	—		"	
R.30	±.030	R.300	—		R-G	
2.50	±.030	2.500	—		Vern	ML-06
2.460	±.010	2.460	—		"	
.375	±.010	.375	—		"	
.830	±.010	.827	—		"	
Ø.166	+0.005 -0.001	Ø.160	—		"	
Ø.500	+0.006 -0.001	Ø.500	—		"	
Ø.750 X L.150	±.010 X ±.010	Ø.750 X L.150	—		"	
.254	±.0005	.256	—		"	
.20	±.030	.200	—		"	
.50	±.030	.498	—		"	
Ø.63	±.010	.625	—		"	
.83	±.030	.829	—		"	
.60	±.030	.599	—		"	
3.80	±.030	3.800	—		"	
Ø1.660	±.010	Ø1.662	—		"	
Ø1.170	+0.005 -0.000	Ø1.171	—		"	
R.03	±.030	R.030	—		R-G	
.10	±.030	.100	—		Vern	ML-06
Ø.615	+0.008 -0.001	Ø.615	—		"	
.830	±.010	.828	—		"	

Measured by: DAS	Audited by:	Preliminary Approval:
Date: 14/05/07	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

